

Work Order ID 59967

Tuesday, June 22, 2010 9:59:33 AM



Page 1

Item ID: D350-591-311

Revision ID:

Accept



Item Name: Heli-Access-Step, Long LH

Setup Start



Start Date: 6/22/2010 Start Qty: 5.00

Stop



Required Date: 7/20/2010 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

RT

Date: *10-6-27*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002

Example

HJ for BG 10/07/27

5/10/28

110



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod *1112860*
1114242

3-Grind End Plate flush

10.07.20

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 7/20/2010 Req'd Qty: 5.00

Reference:

Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start
Stop

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

1000.20

75
LH

8/10/07/20

10.07.20

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 7/20/2010 Req'd Qty: 5.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

JS

10/07/20

(X5)

4

QC

Memo

0.00

Quality Control

180

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod *M112860*

6-Grind End Plate flush

7-Install last rivet as per Dwg.

PK 10.07.22

5

8

W/O:		WORK ORDER CHANGES						
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Start



Stop



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Required Date: 7/20/2010 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

⑤ PD 10.07.22

④ 5

5 BL 10-7-23

W/O:		WORK ORDER CHANGES					
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Required Date: 7/20/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:30
OVEN TEMPERATURE: 320°
FINISH TIME: 12:00

5 10-7-23

230

Wing Walk as per dwg QSI005 4.4 Batch 114432

0.00



HandFinish

Memo

0.00

Hand Finishing

10 07 26 5

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 10/07/20

45
44

W/O:		WORK ORDER CHANGES					
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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10.7.278

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8/10/12/28

25.4

270



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD350-591-311

Location:

New B

8/10/12/28 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/29 *[Signature]*10-7-28
(5)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 59967



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
 IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1 End Plate		Manufactured	No			110	Each	3.0000	1	5		10.07.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA	859596	3				5			
					57926	3							
D3219-1 Plate		Manufactured	No			110	Each	113.0000	2	10		10.07.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		113							
					58550	17							
					59597	96				10			
D3272-1 Step		Manufactured	No			110	Each	10.0000	1	5		10.07.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA	859972	10				5			
					59952	10							

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 59967



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 5.00

Required Qty: 5.00

D3065-041 Manufactured No

180 Each

14.0000

1

5



Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA

359678

14

58160

1

58536

13



10.07.22

5

D3066-1 Manufactured No

180 Each

77.0000

2

10



Spacer

Location

Loc Qty

Loc Code

WA

359596

77

58540

77



10.07.22

10

D3067-1 Manufactured No

180 Each

3.0000

1

5



End Plate

Location

Loc Qty

Loc Code

WA

359596

3

57926

3



10.07.22

5

MS20600-AD4W4 Purchased No

180 Each

959.0000

16

80



Rivets

Location

Loc Qty

Loc Code

ST321

959

113368

62

114181

11

114718

2

114935

884



10.07.22

80

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 5.00

Required Qty: 5.00

AN3-35A

Purchased

No

250

Each

17.0000



Bolt

Location

Loc Qty

Loc Code

ST353

17

114784

17

250

Each

478.0000

AN4-13A

Purchased

No



Bolt

Location

Loc Qty

Loc Code

ST357

478

114941

478

250

Each

269.0000

AN5-36A

Purchased

No



Bolt

Location

Loc Qty

Loc Code

ST341

269

114292

19

114784

50

114941

200

250

Each

0.0000

AN960JD10

NAS1149D0363J

Purchased

No



Washer

AN960JD416

NAS1149D0463J

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST357

6

107939

6

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M115016 10/7/27

10-7-27

10/7/27

M115107 10/7/27

M115000 10/7/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 5.00

Required Qty: 5.00

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

Washer

D2230-3 Manufactured No

250 Each

179.0000

Lug

Location

Loc Qty

Loc Code

ST476

179

55452

2

59115

17

59418

160

D2618

Manufactured No

250 Each

25.0000

Bushing

Location

Loc Qty

Loc Code

ST020

25

56892

1

57829

24

D2856-400 Manufactured No

250 f

182.7820

Abraison Strip

Location

Loc Qty

Loc Code

ST403

182.782

56626

182.782

D3235-1

Manufactured No

250 Each

103.0000

Mounting Lug

Location

Loc Qty

Loc Code

ST471

103

58717

43

59125

60

4 20

4 20

2 10

6.00 0.6 3

2 10

10

M114742 10/7/27

10/7/27

20 3x 7x
B59425 B60193
10/7/27

10/7/27

10/7/27

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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 5.00

Required Qty: 5.00

D3278-041

Manufactured No

250

Each

60.0000



Support Assembly

Location

Loc Qty

Loc Code

ST471

60

59633

60

MS21042L3

Purchased No

250

Each

3,085.000



Nut

Location

Loc Qty

Loc Code

ST300

3085

114523

585

114718

500

114784

2000

MS21042L4

Purchased No

250

Each

3,046.000



Nut

Location

Loc Qty

Loc Code

ST300

3046

113422

68

114523

28

114718

950

114784

2000

MS21042L5

Purchased No

250

Each

681.0000



Nut

Location

Loc Qty

Loc Code

ST139

500

114813

500

ST300

181

114449

181



1

5

10-7-07

SP



2

10

10-7-07

SP



8

140

10-7-07

SP



2

10

1106785

10-7-27

SP

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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI-LONG	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *59967*

2010-6-27

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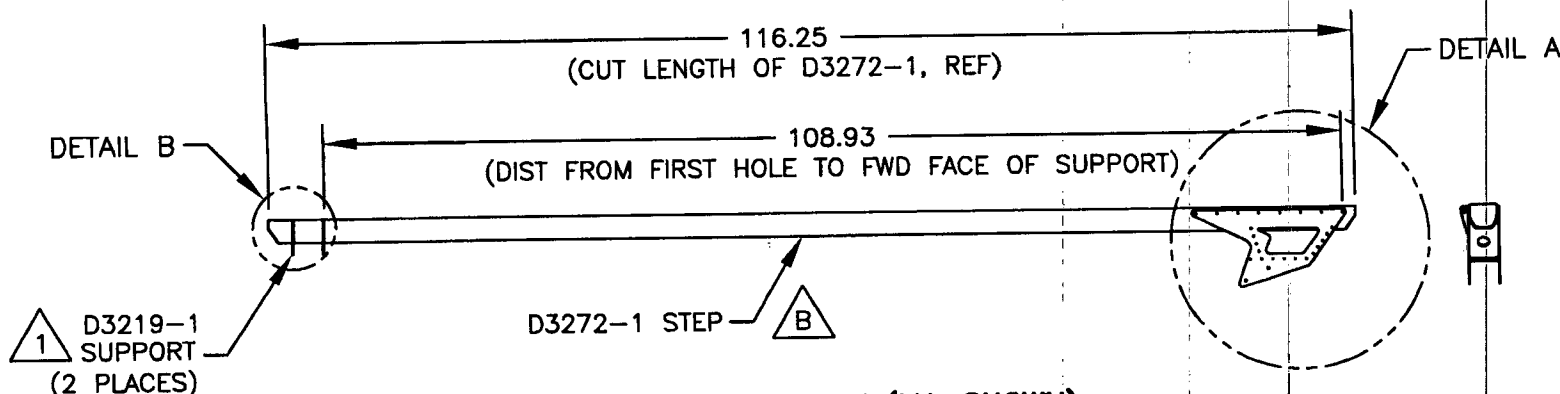
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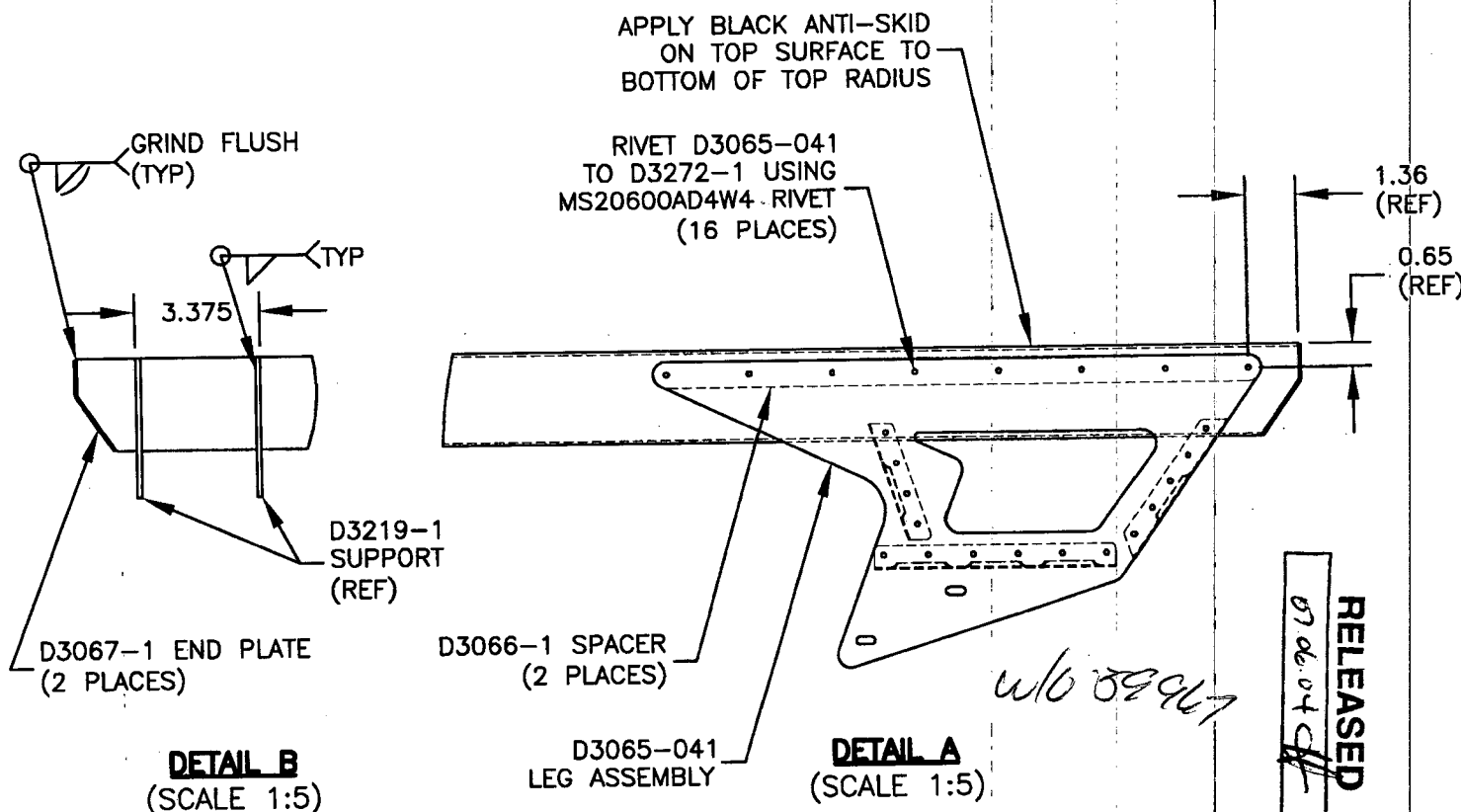
NOTE: Date & initial all entries

DART

DESIGN	90	DRAWN BY	90	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	CE	APPROVED	90	DRAWING NO.	D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B	SHEET 2 OF 3
		SCALE	1:20		



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

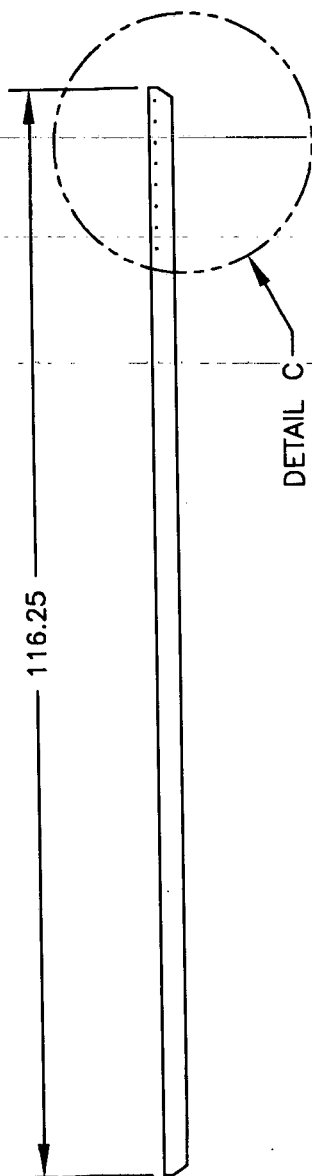
NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

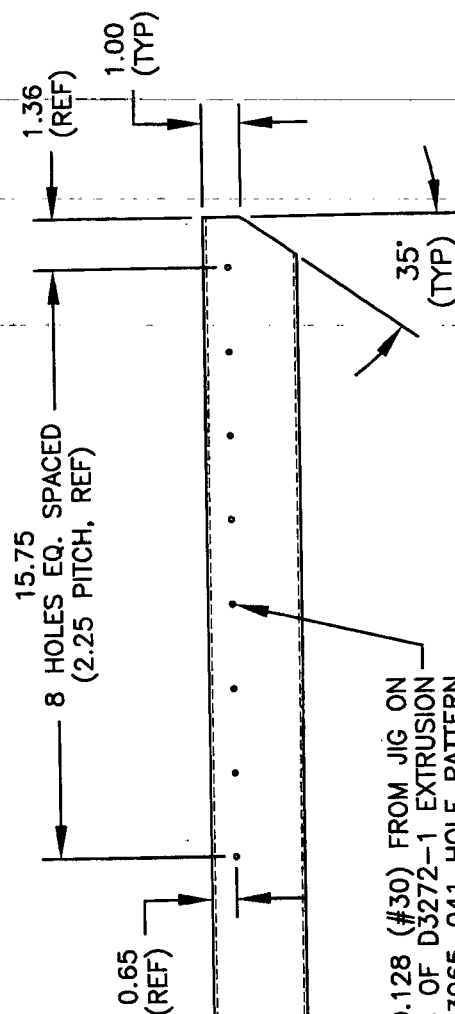
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C

(SCALE 1:5)

w/b 52967

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.